

Date: Tuesday, 4/29/2008 3:44:26 PM  
 User: David Duval

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : GLARESHIELD ASSEMBLY  
 Job Number : 38892  
 Estimate Number : 13291  
 P.O. Number :  
 This Issue : 4/29/2008 S.O. No. : R+D  
 Prsht Rev. : NC  
 First Issue : // Type : SMALL / MED FAB  
 Previous Run :  
 Written By : DD 08/04/30  
 Checked & Approved By :  
 Comment : Est Rev:A 08-04-29 new issue DD verified by:ec

Part Number : D3690041  
 Drawing Number : PRELIM  
 Project Number :  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 5/6/2008 Qty: 1 Um: Each

Additional Product

# PRELIMINARY ISSUE ~~PROTOTYPE~~

Job Number:



FOR ENGINEERING USE ONLY

FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D36901 Glareshield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Glareshield  
 batch: B38869 080509 1

3.0 D3697041 Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Tube Assembly  
 batch: B38871 080509 1

4.0 D36981 Support Angle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Support Angle  
 batch: B38877 080509 1

5.0 D37971 Ground Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Ground Plate  
 batch: B38877 080509 1

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Drawing Name: GLARESHIELD ASSEMBLY

Job Number: 38892

Part Number: D3690041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 AN960JD3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

batch: M107989

080509

16

7.0 MS20426AD34 RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

RIVET

batch: M105978

080509

2

8.0 MS20470AD33 Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivet, Universal Head

batch: N/A

08.05.09

9.0 MS20470AD34 Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total: 36.0000 Each(s)

Rivet, Universal Head

batch: M15541

080509

36

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D3690

080509

11.0 QC5 INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL

Comment: INSPECT WORK TO CURRENT STEP

08.05.09

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and stamp

Location:

N/A 08.05.09

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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: GLARESHIELD ASSEMBLY

Job Number: 38892

Part Number: D3690041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.13 Prototype

Job Completion



Charge to  
W/O #00235

U 08-05-09

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

Date: 25-Apr-08

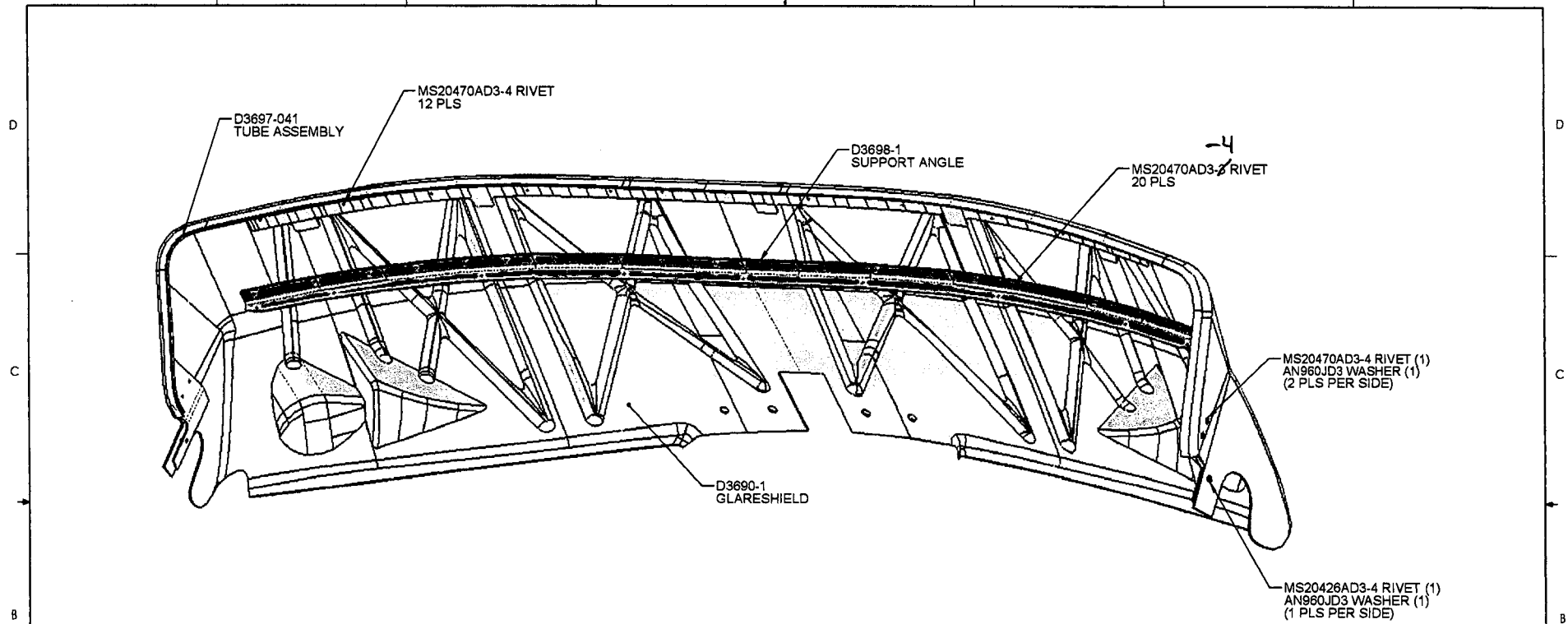
Product Name: B412 Glareshield

Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1 ✓	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3 ✓	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4 ✓	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1 ✓	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1 ✓	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041 ✓	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041 ✓	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042 ✓	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041 ✓	Glareshield Assy	31/03/2008	y	09-May-08		

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3696-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
6	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-4	RIVET
20	MS20470AD3-4	RIVET
36	MS20470AD3-4	RIVET

**D3690-041 GLARESHIELD ASSEMBLY**

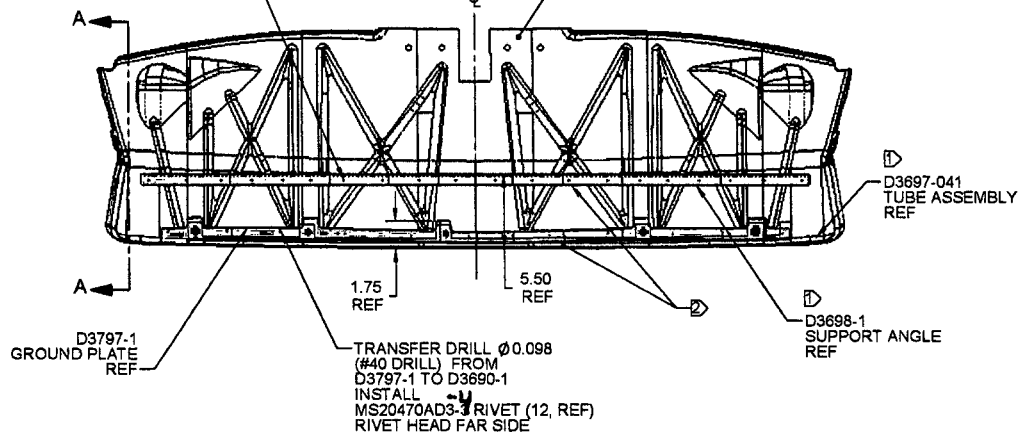
*Handwritten signature and date: 08.04.30*

A	NEW ISSUE	RF	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3690	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	1:4
DATE	08.04.30	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL OR OTHER PURPOSE WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

TRANSFER DRILL  $\phi 0.098$   
(#40 DRILL) FROM  
D3698-1 TO D3690-1  
INSTALL  
MS20470AD3-4 RIVET (20, REF)  
RIVET HEAD FAR SIDE

D3690-1  
GLARESHIELD  
REF



TRANSFER DRILL  $\phi 0.098$   
(#40 DRILL) FROM  
D3697-041 TO D3690-1  
INSTALL  
MS20426AD3-4 RIVET (1, REF)  
AN980JD3 WASHER (1, REF FROM FAR SIDE)  
(1 PER SIDE)

0.15  
REF

TRANSFER DRILL  $\phi 0.098$   
(#40 DRILL) FROM  
D3697-041 TO D3690-1  
INSTALL  
MS20470AD3-4 RIVET (1, REF)  
AN980JD3 WASHER (1, REF FROM FAR SIDE)  
(2 PER SIDE)

### SECTION A-A



### D3690-041 GLARESHIELD ASSEMBLY

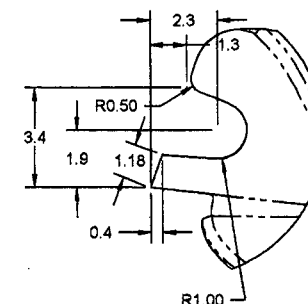
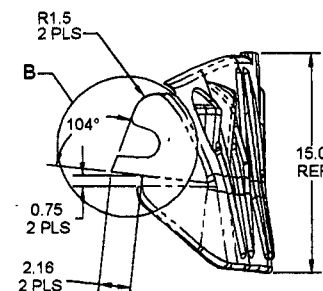
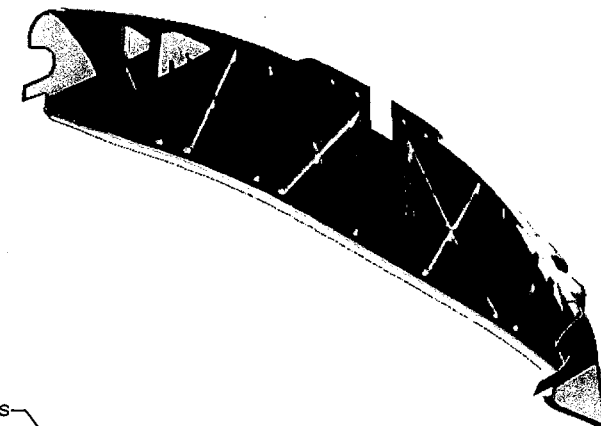
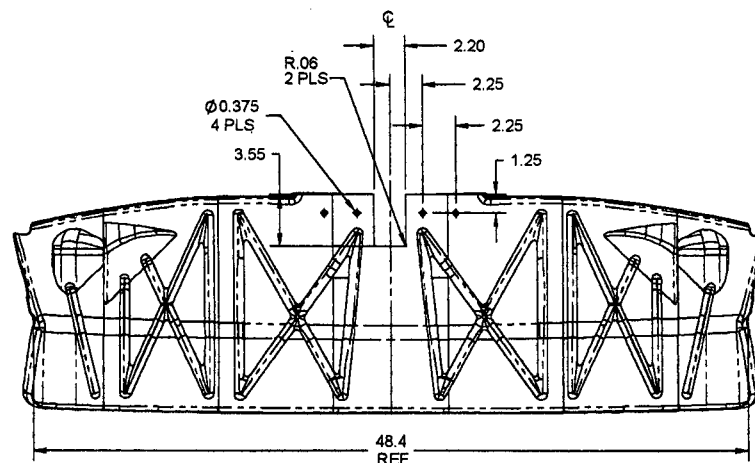
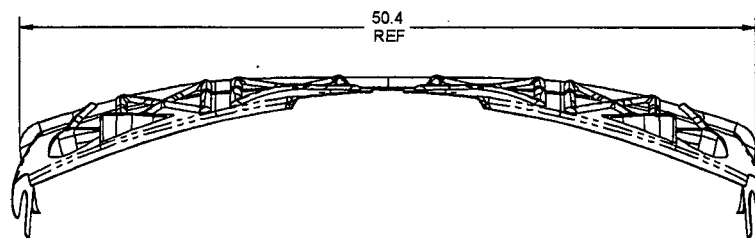
**PRELIMINARY ISSUE**

08.04.25  
*[Signature]*

#### NOTES:

- 1) APPLY 3M EPOXY ADHESIVE DP-100 FR TO INSTALL D3697-041 ON TO D3690-1 GLARESHIELD TOUCH UP ADHESIVE WITH FLAT BLACK PAINT AFTER ADHESIVE IS CURED
- 2) CENTER D3697-041, D3698-1, AND D3797-1 ON TO D3690-1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 3.04 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	1:8
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DETAIL B  
SCALE 1:4

# D3690-1 GLARESHIELD

PRELIMINARY ISSUE

*MP 08.03.25*

## NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5V133 BLACK FLAT LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT PER QSI 022  
TRIM PER MOLD DT EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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